

Work Order ID 83030

83030

Page 1

Printed 12/04/12 12:58:25 PM

Item ID: D206-642-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-241

CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N9000040100

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Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

SAD 12-04-23

Rm

12-5-11

SAD 12-05-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

SAD

12-05-14

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

12-05-14

W/O:		WORK ORDER CHANGES					
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Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to Ø0.3125"								
	2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.								
	3-Deburr tube and blow out chips from inside the tube								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

①
SAD
12-05-14

7/6
12-5-15

① SAD 12-05-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail
(without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

CF 125-15

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1 0 BE R-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop

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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12-5-15 Time: 2:10 PM

Finish Date: 12-5-16 Time: 10:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M121221

Sikaflex expire date: 13-1-4

1 SAO 12-05-15

Rm/CE 12-5-15

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 SE 12-05-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 83030

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Replacement Skidtube

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod m120164

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 12/05/12

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

BE 12/05/16→ CF 12-5-22DP 12-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 83030

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83030

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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

0.00

210

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

CF 12-5-23

220

QC10- Inspect visual per QSI004- ground welds

0.00

220

QC

Memo

0.00

Quality Control

QC9

CP 12:05:30

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

5/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 83030

April-12-12 12:58:25 PM

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:45 OVEN TEMPERATURE: 320 °F FINISH TIME: 9:15								
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									

1 7/6 12-5-31

1X ✓ MF 12/06/04

1x 9 12/06/06

W121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

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Start Date: 12/04/2012 **Start Qty:** 1.00 ***1***

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Required Date: 26/04/2012 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp. Stamp

0.00

270

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 12/409

Sikaflex expire date: 13/07

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 121 409

Sikaflex expire date: 13/07

5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4

A/R Batch: 12163
Batch: 12163

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

310

0.00

310

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-664-241

Location:

PPP Rev:

PPP 83026

12/6/21 (1)

320

0.00

320

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/6/21

MC 12-06-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by: ECIPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	24.0000	1	1			
D2620									**			SAD 12-04-23	
Skidtube, 206 Skidtube													

Location

Loc Qty

Loc Code

LG

24

77999

1

79543

2

79544

1

81365

1

81366

1

82028

12

82517

6

D3286-1

Manufactured No

110

Each

111.0000

2

2

D3286-1

Doubler

**

SAD 12-05-15

Location

Loc Qty

Loc Code

LG002

223

74872

6

78014

21

79556

78

ST046

-112

76772

6

W/O:		WORK ORDER CHANGES					
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D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2647 Manufactured No

110

Each

16.0000

1

1

D2647

Cap

**

BE 12/04/23
B79563

Location

Loc Qty

Loc Code

LG002

16

75482

16

D2654-3 Manufactured No

180

Each

9.0000

1

1

D2654-3

Web

**

Location

Loc Qty

Loc Code

LG

9

78988

1

82106

8

CR3212-4-04 Purchased No

180

Each

5,412.000

52

52

CR3212-4-04

Cherry Rivet

**

① Km 12-5-15
SAD 2005-15

Location

Loc Qty

Loc Code

ST331

154

116471

74

117816

3

118686

1

118840

16

119017

60

st510

5258

119075

5258

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 3

Work Order ID: 83030

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

83030

D206-642-241

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,108.000

18

18

D2649

Cross Bolt Spacer

**

BE 12/05/12

Location

Loc Qty

Loc Code

LG

769

77574

2

79502

65

79503

399

79564

296

79565

7

LG001

339

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

212

10

8

D3286-3

Manufactured No

200

Each

62.0000

2

2

D3286-3

Spacer

**

BE 12/05/12

Location

Loc Qty

Loc Code

LG001

62

74117

1

79557

61

2

April-12-12 12:58:29 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 4

Work Order ID: 83030

83030

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210

Each

118.0000

1

1

D2680-041

Nut Plate

**

CF 12-5-23

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

2

76790

2

CR3212-4-03

Purchased

No

210

Each

1,382.000

2

2

CR3212-4-03

Cherry Rivet

**

CF 12-5-23

Location

Loc Qty

Loc Code

FP002

394

114859

394

ST331

988

110139

2

119017

986

CCR264SS3-3

Purchased

No

210

Each

497.0000

2

2

CCR264SS3-3

Cherry Rivet

**

CF 12-5-23

Location

Loc Qty

Loc Code

ST331

497

113973

2

117849

109

119017

386

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 5

Work Order ID: 83030

83030

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

80.0000

1

1

D2646

Aft Cap

**

1

(2P)

12/06/06

Location

Loc Qty

Loc Code

FP002

80

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

22

79500

1

79562 ✓

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 6

Work Order ID: 83030

83030

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

270

Each

773.0000

18

18

D2651-1

Plug

**

18

2P

12/06/06

Location

Loc Qty

Loc Code

FP

200

FP001

601

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

18

79234

222

FP-A

-28

77559

1

78124

5

81809

66

81954

200

82573 ✓

200

AN960JD416

✓NAS1149D0463J Purchased

No

270

Each

10.0000

1

1

AN960JD416

Washer

**

1

2P

12/06/06

Location

Loc Qty

Loc Code

ST351

10

116289

10

April-12-12 12:58:29 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Work Order ID: 83030

83030

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

270 Each

1,552.000 18 18

D2651-3

O-Ring

**

18

(28)

12/06/06

Location

Loc Qty

Loc Code

FP001

16

61962

12

73828

4

FP-A

1536

78126 ✓

1536

MS27039-1-08

Purchased

No

270 Each

1,647.000 46 46

MS27039-1-08

Screw

**

46

(28)

12/06/06

Location

Loc Qty

Loc Code

ST291

1647

117423

81

119075

1

120308 ✓

804

121011

261

121243

500

ALS4-1032-130

Purchased

No

270 Each

6,003.000 44 44

ALS4-1032-130

Insert

**

44

(28)

12/06/06

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

2798

120807

798

120837

2000

ST282

3000

121269 ✓

3000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 8

Work Order ID: 83030

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

83030

D206-642-241

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

270

Each

153.0000

1

1

MS27039-4-06

Screw

**

1

SP

12/06/06

Location

Loc Qty

Loc Code

ST292

153

119075 ✓

153

AN960JD10L

X

NAS1149D0332J

Purchased

No

270

Each

0.0000

46

46

*AN960JD10L *

Washer

D3537-1

Manufactured

No

270

Each

42.0000

4

4

D3537-1

Wearpad

**

4

SP

12/06/06

Location

Loc Qty

Loc Code

FG

10

84091 ✓

79833

10

FP002

32

83056.

69817

5

80337

4

81361

23

D3537-3

Manufactured

No

270

Each

33.0000

1

1

D3537-3

Wearpad

**

1

SP

12/06/06

Location

Loc Qty

Loc Code

FP002

33

81363 ✓

78836

24

80338

9

missing one

April-12-12 12:58:29 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 9

Work Order ID: 83030

83030

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-13

Manufactured No

270 Each

28.0000 1 1

D3535-13

Wearshoe

**

1 2P 12/06/06

Location

Loc Qty

Loc Code

FP001

28

78962 ✓

3

79850

1

80327

12

81353

12

D3536-13

Manufactured No

270 Each

35.0000 1 1

D3536-13

Gasket

**

1 2P 12/06/06

Location

Loc Qty

Loc Code

FP002

35

78964

11

81344 ✓

24

D3535-21

Manufactured No

270 Each

21.0000 1 1

D3535-21

Wearshoe

**

1 2P 12/06/06

Location

Loc Qty

Loc Code

FP001

6

80329

6

FP002

15

78987 ✓

15

D3536-21

Manufactured No

270 Each

19.0000 1 1

D3536-21

Gasket

**

1 2P 12/06/06

Location

Loc Qty

Loc Code

FP002

19

78966

19

April-12-12 12:58:29 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:58:29 PM

Page 10

Work Order ID: 83030

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

83030

D206-642-241

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-33
D3535-33
Wearshoe

Manufactured No

270 Each

18.0000

**

1

SP

12/06/06

Location

Loc Qty

Loc Code

FP001

82751 ✓

18

70462

3

78984

15

D3536-33
D3536-33
Gasket

Manufactured No

270 Each

24.0000

**

1

SP

12/06/06

Location

Loc Qty

Loc Code

FP002

70465 ✓

24

81341

11

81341

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

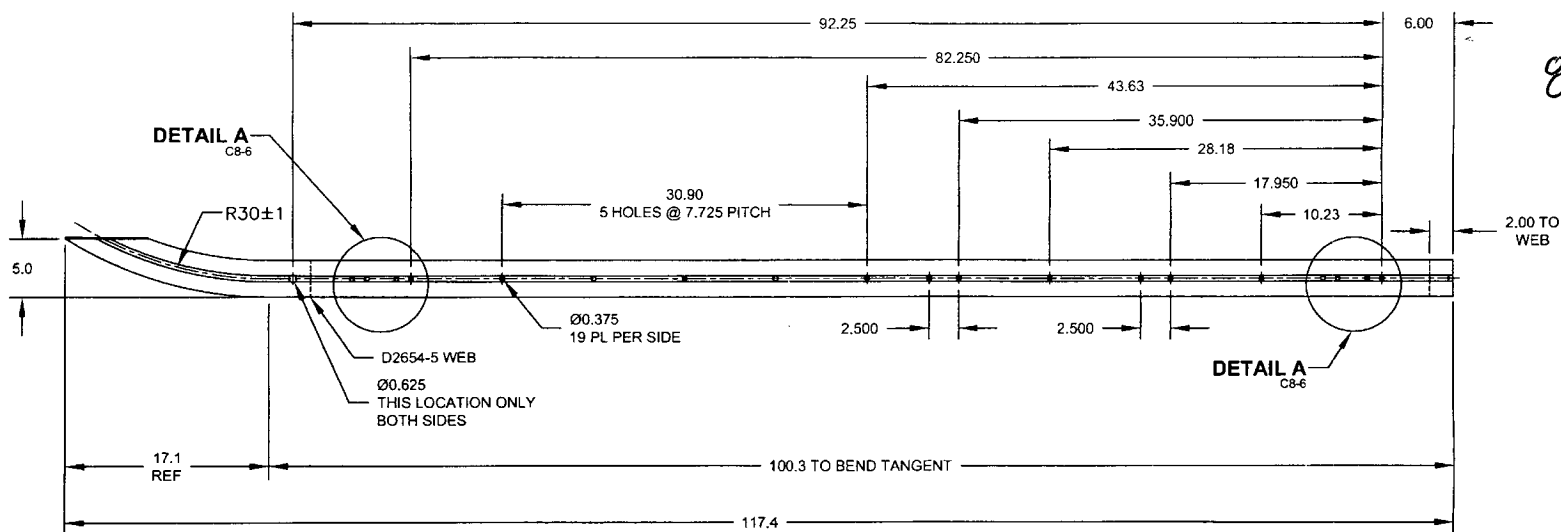
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. B3030 MJS
12/04/12

RELEASED
08.07.23/17

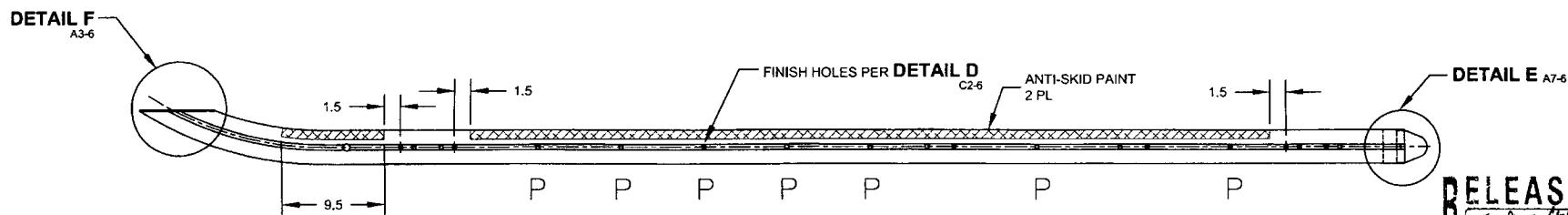
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



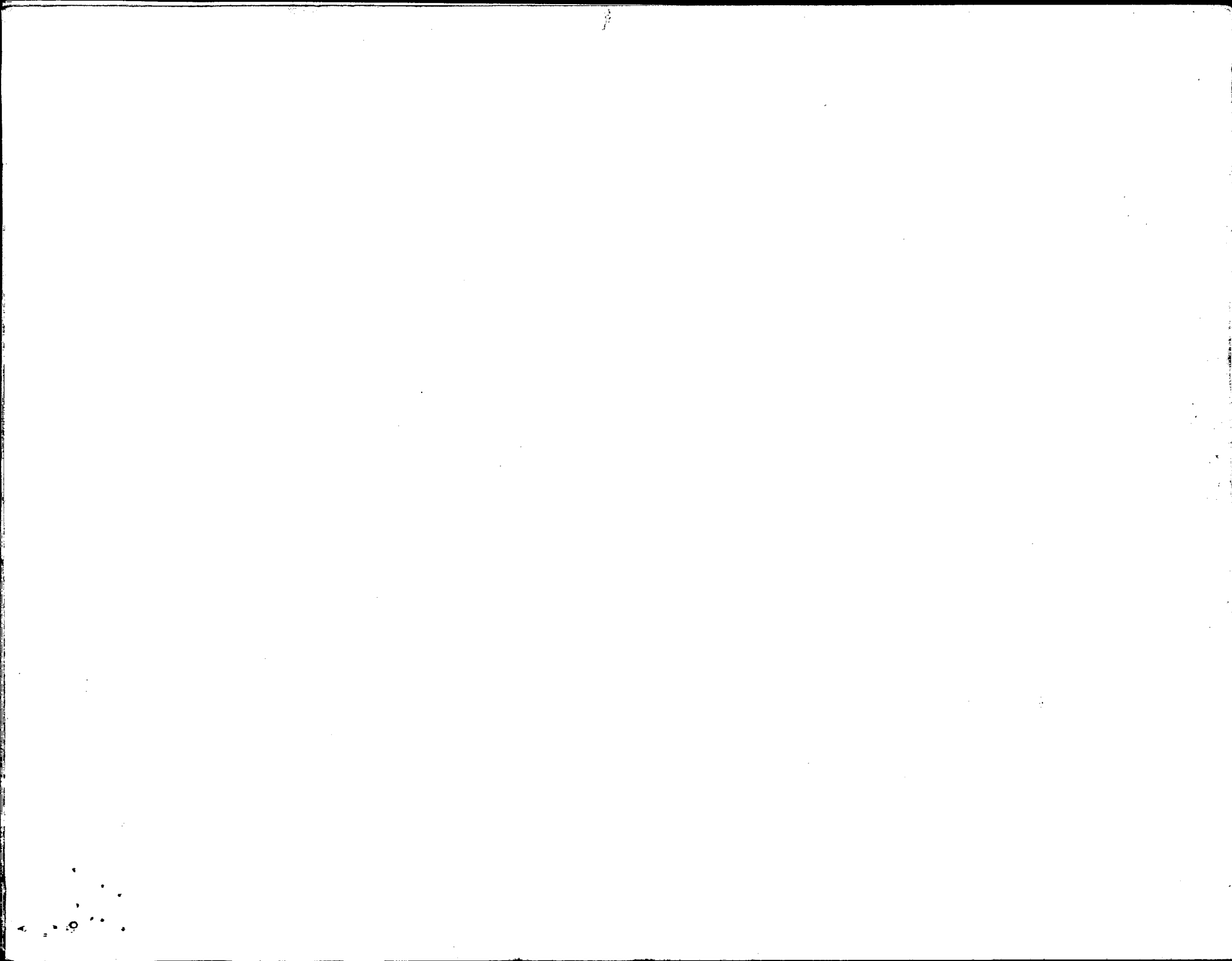
D2650-5 BENDING/DRILLING DETAIL

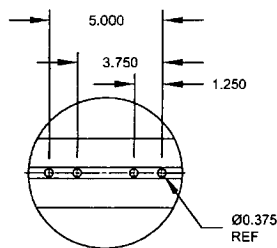


D2650-5 ASSEMBLY/FINISHING DETAIL

RELEASED

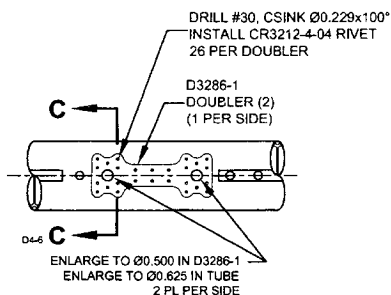
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





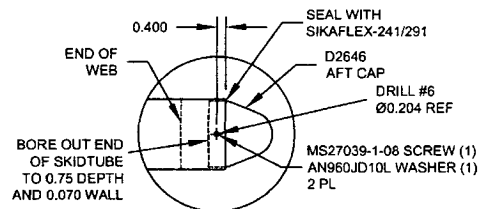
DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5



DETAIL B
SCALE 2X

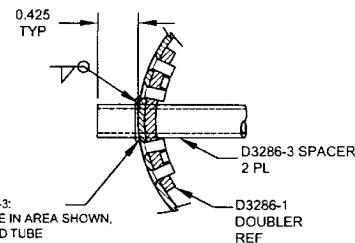
C3-2
C3-3



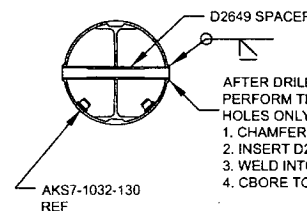
DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE



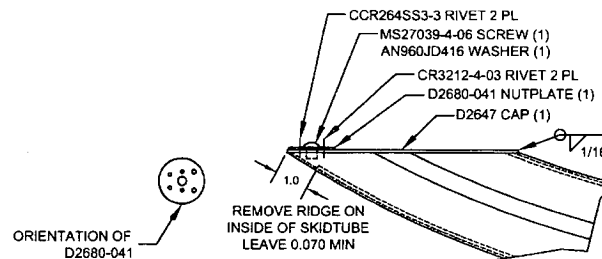
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP

B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE

B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-2018

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



NO. 295

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83028
Part number: A206-642-241
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 12.05.23
Welder Barclay Elliott Date of Test Coupon 12.05.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld